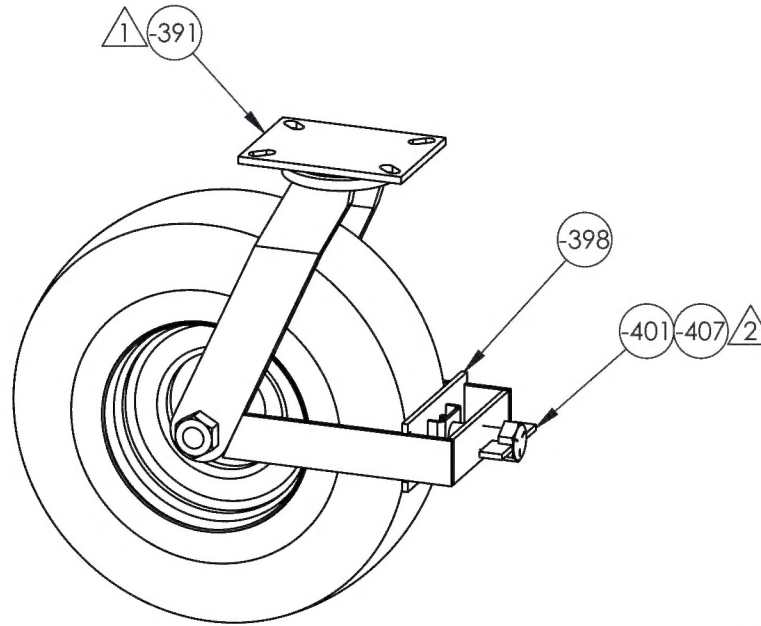


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION	4/26/2017	SM	JAG



-335

CASTER ASSY

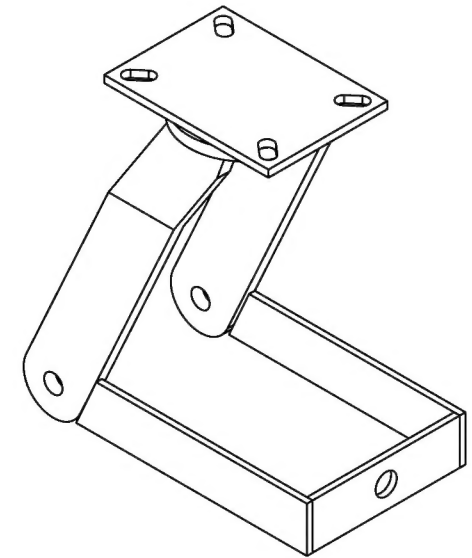
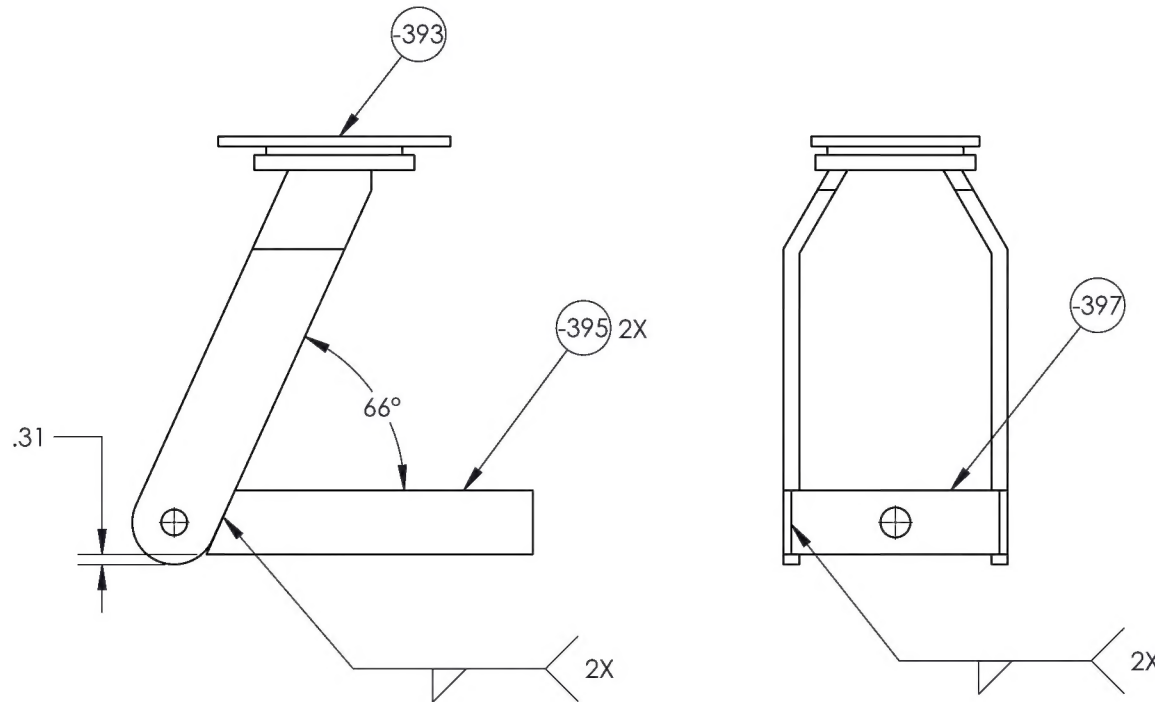
NOTES:

- 1 REMOVE TIRE AND AXEL FROM -391 PRIOR TO WELDING AND PLATING. RE-INSTALL AFTER PLATING.
- 2 INSTALL -407 SO THAT -401 CAN STILL ROTATE FREELY.

ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.				
		X		-391	1	CASTER WELDMENT			2	TITLE			
		1		-393		SWIVEL CASTER		(MCMASTER-CARR - 28035T12) MODIFIED	2	SUPPORT DOLLY, TAILBOOM			
		2		-395		BRAKE SUPPORT	A36/1018/1020 HR		3	DWG NO. RB T102012-335			
		1		-397		THREADED BRAKE PLATE	A36/1018/1020 HR		4	REV 1			
X				-398	1	BRAKE PLATE WELDMENT			5	MAT'L			
1				-399		BRAKE PLATE	A36/1018/1020 HR		6	UNLESS OTHERWISE SPECIFIED			
1				-400		BRAKE PLATE TAB	A36/1018/1020 HR		7	DIMENSIONS ARE IN INCHES			
	X			-401	1	BRAKE BOLT WELDMENT			8	.XXX ± .005 FRACTIONS ± 1/8			
	2			-403		BRAKE BOLT TAB	A36/1018/1020 HR		9	.XX ± .01 ANGLES ± 5°			
	1		B/O	-405		BRAKE BOLT	STEEL	1-14 x 3 (MCMASTER-CARR # 92865A524)	8	.X ± .1 SURFACES = 125°			
			B/O	-407	1	SPRING PIN	STEEL	1/4 x 1-1/2 (MCMASTER-CARR # 90692A746)	1	1. BREAK ALL SHARP EDGES			
	ASSM -401	ASSM -391								.015 x 45° OR .015R			
										2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
										3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009			
										USED ON MODEL			
										212, 214B, 214ST, 412			
										SCALE 1:8			
										DATE 11/15/2016			
										SHEET 1 OF 9			

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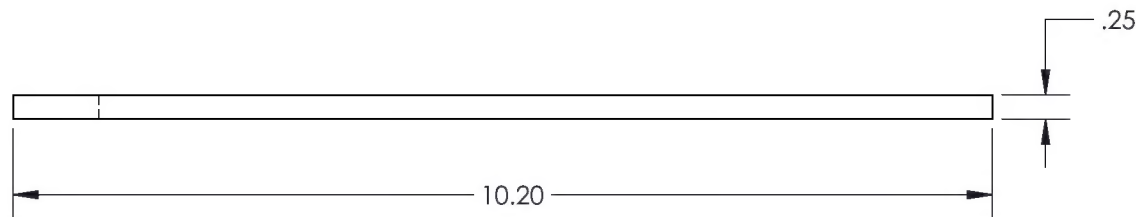
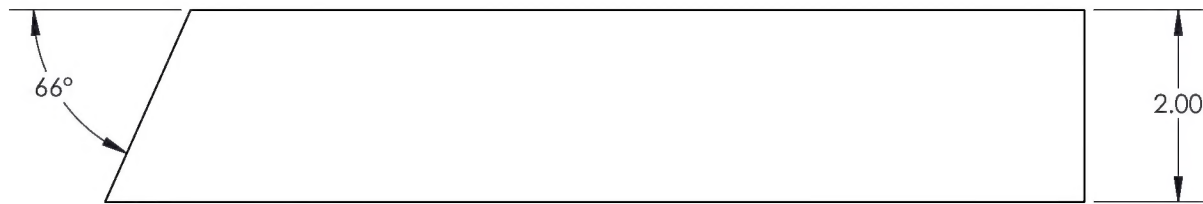
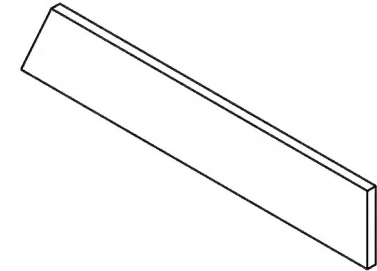
-391

CASTER WELDMENT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-391	REV 1
MAT'L ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	212, 214B, 214ST, 412
APPROVED: GILBERT	
SCALE 1:6	DATE 11/15/2016
SHEET 2 OF 9	

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				APPROVED



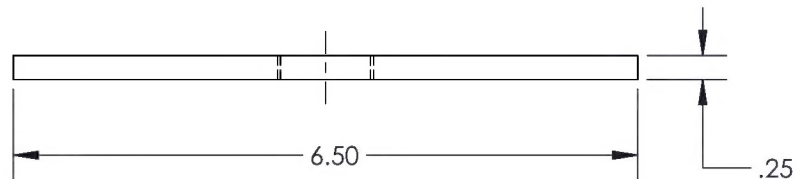
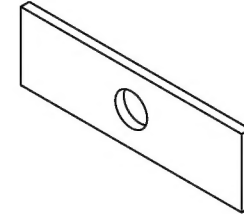
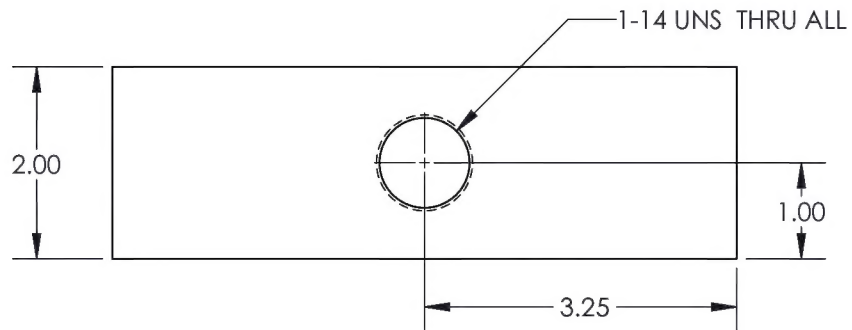
(-395)

BRAKE SUPPORT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-395	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -391 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 11/15/2016
	SHEET 3 OF 9

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				APPROVED



(-397)

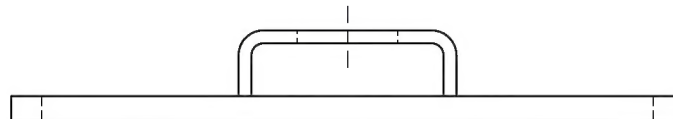
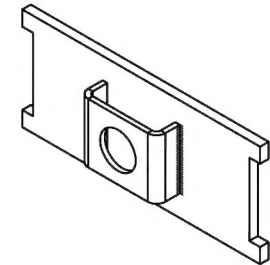
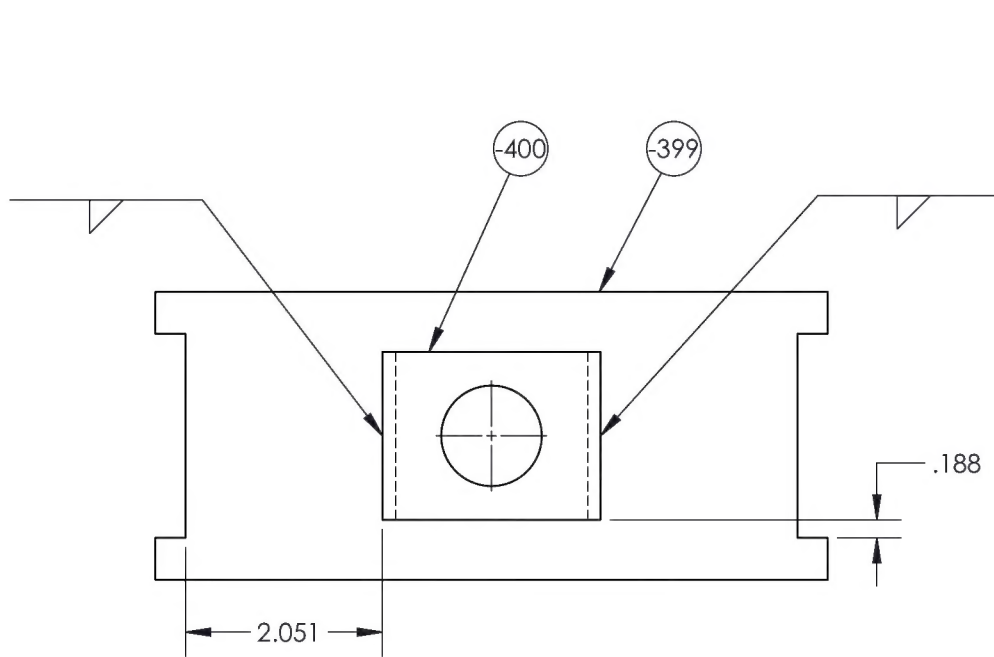
THREADED BRAKE PLATE



TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-397	
REV		1	
MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -391 WELDMENT		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
DRAWN BY: MACKOVJAK		.X ± .1 SURFACES = 125°	
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 1:2		DATE 11/15/2016	
		SHEET 4 OF 9	

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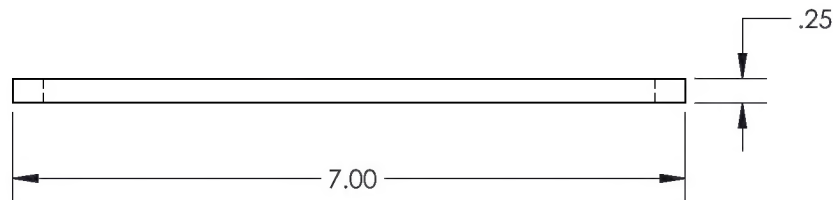
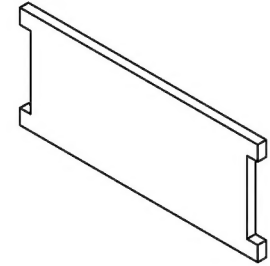
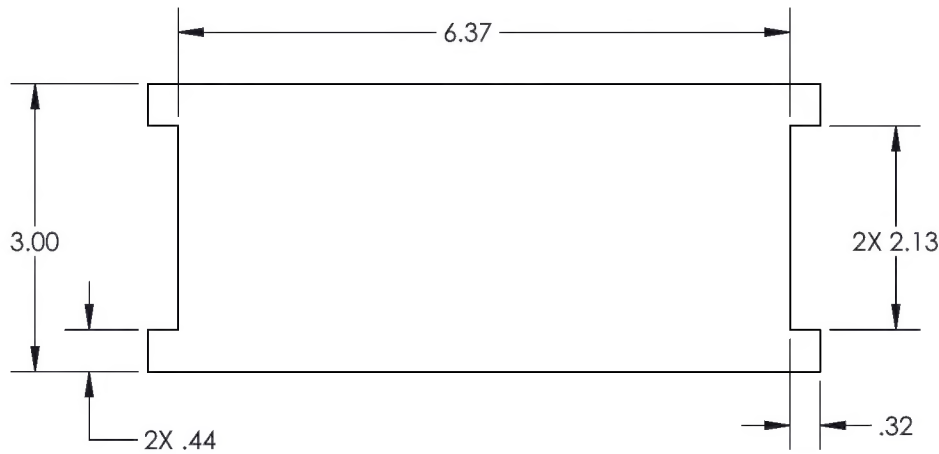
-398

BRAKE PLATE WELDMENT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-398	REV 1
MAT'L ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	212, 214, 214ST, 412
APPROVED: GILBERT	
SCALE 1:2	DATE 11/15/2016
SHEET 5 OF 9	

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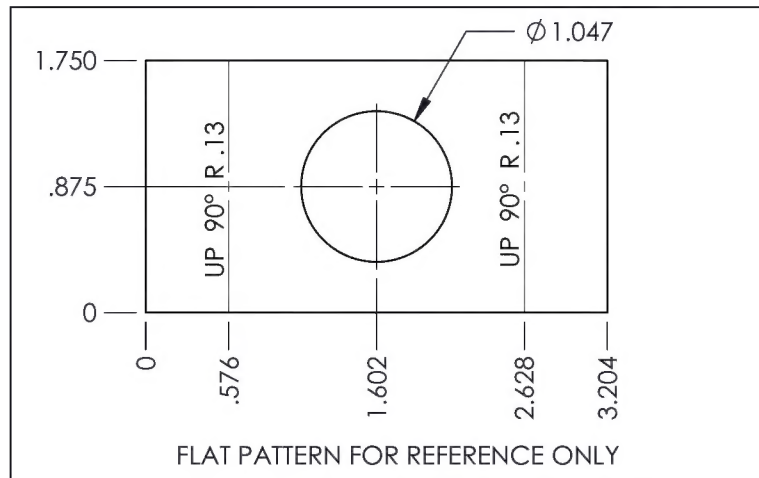
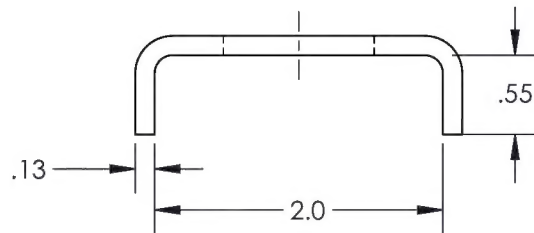
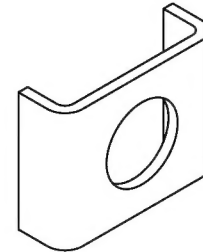
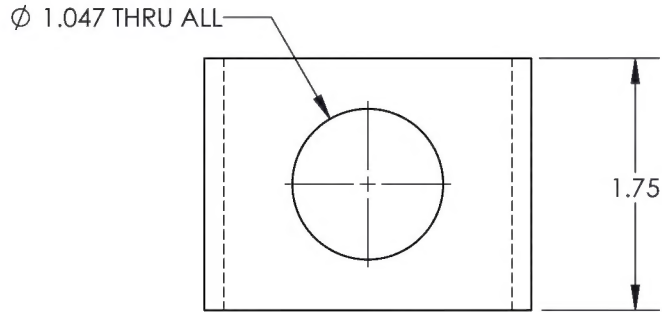
-399

BRAKE PLATE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-399	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -398 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	DATE 11/15/2016
	SHEET 6 OF 9

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				APPROVED



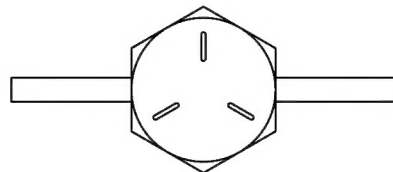
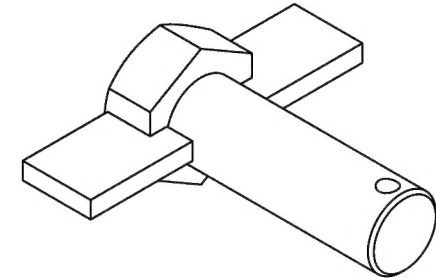
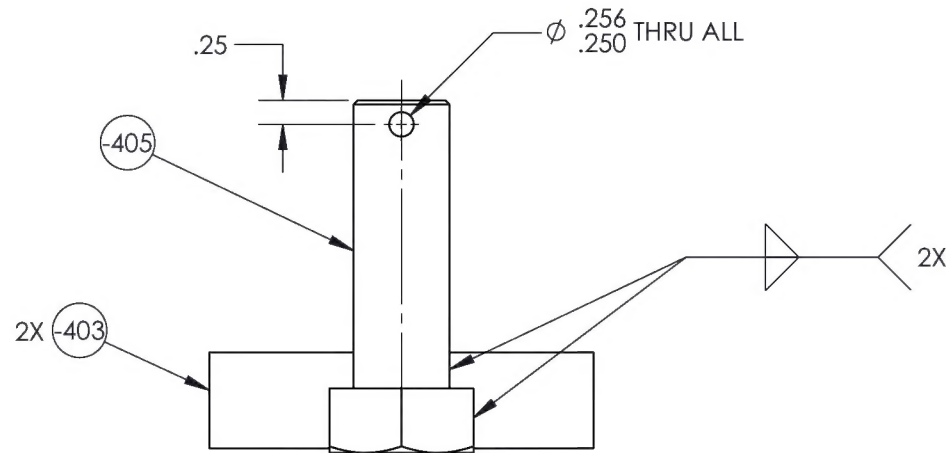
(-400)

BRAKE PLATE TAB

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-400	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -398 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 3:4	DATE 11/15/2016
	SHEET 7 OF 9

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				APPROVED



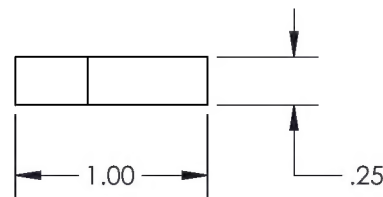
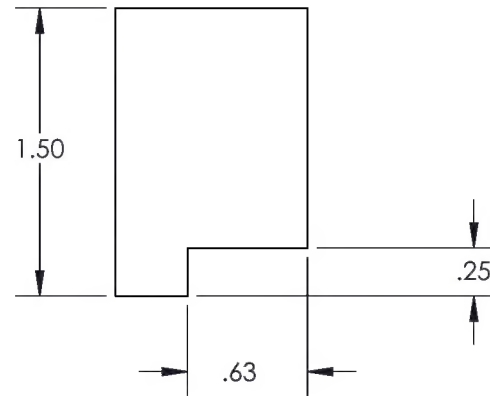
-401

BRAKE BOLT WELDMENT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-401	REV 1
MAT'L ASTM B633 TYPE I SC 2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT ZINC PLATE	.XXX ± .010 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	212, 214B, 214ST
APPROVED: GILBERT	
SCALE 1:2	DATE 11/15/2016
SHEET 8 OF 9	

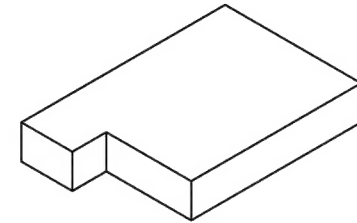
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(-403)

BRAKE BOLT TAB



DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-403	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -401 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 11/15/2016
	SHEET 9 OF 9